

Date: Wednesday, 1/2/2008 11:43:19 AM  
 User: David Duval

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 36546	
Estimate Number : 11142	
P.O. Number : <i>N/A</i>	Part Number : D32072
This Issue : 1/2/2008 S.O. No. : <i>N/A</i>	Drawing Number : D3207 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/9/2008 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est A 04.04.15 New issue KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.1502 sf(s)/Unit Total : 1.5015 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick  
 (M2024T3S.050)  
 Identify for D3207-2 *103210*  
 Batch: *103210* *B 08-1-2*

*(11)*

2.0	SHEAR	SHEAR
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*A*  
*A* *B 08-1-2*



Comment: ~~SHEAR~~  
 (1) Flat pattern makes either D3207-2  
 Cut blank: 6.5100" x 2.880" (+0.020/-0.000) grain along 2.880"

*n/a*

3.0	<del>HAAS1</del>	HAAS CNC VERTICAL MACHINING #1
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Comment: ~~HAAS CNC VERTICAL MACHINING #1~~ *crater set*  
 Machine as per Folio ~~FA341~~ and Dwg D3207  
 Deburr  
 Stack of 10 *B 08-1-2*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*B 08-1-2*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 36546

Part Number: D32072

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/01/03 (+10)

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form 1/2 of stack for D3207-2 as per Dwg D3207

Identify as D3207-2

08-01/03 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/03 (+10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1.



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-01-03 (10)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR 08-01-08 (10)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

MR 08/01/08 (10)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 243A

AS 08/01/08 (10)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/09 (10)

Job Completion

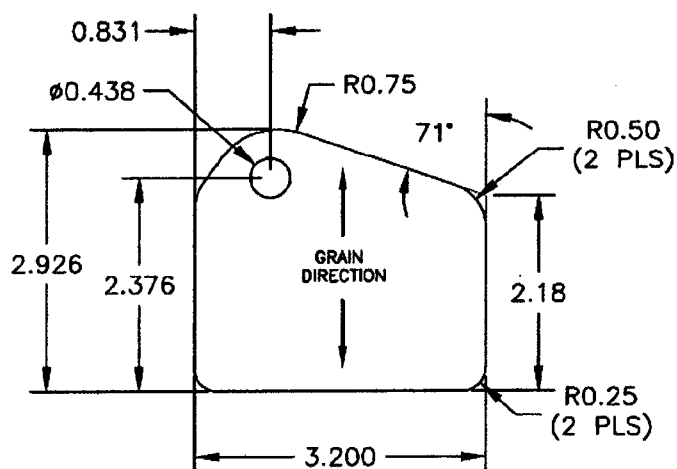
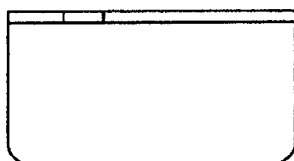


08-01-09

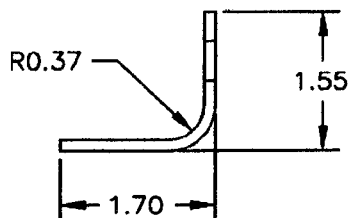
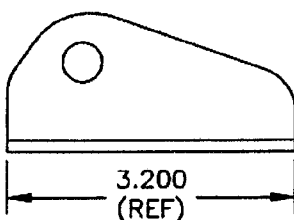


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3207	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

RELEASED  
04.04.05



**D3207-5 FLAT PATTERN**



**D3207-5 BEND DETAIL**

**D3207-5 BRACKET**

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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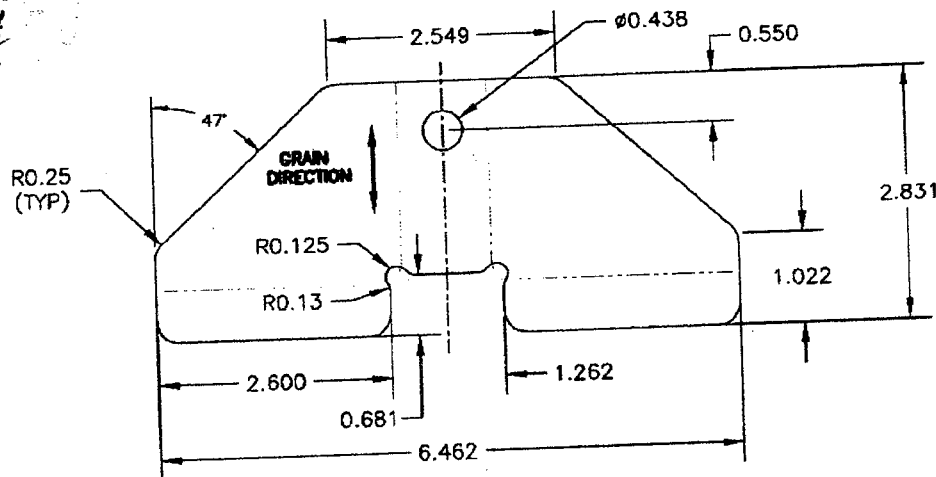
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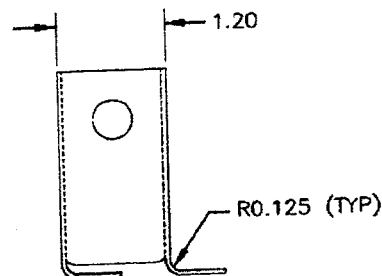
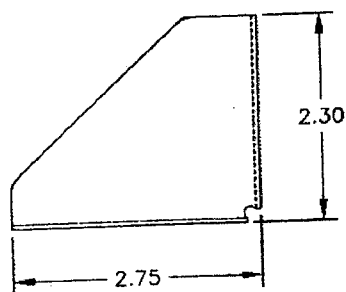
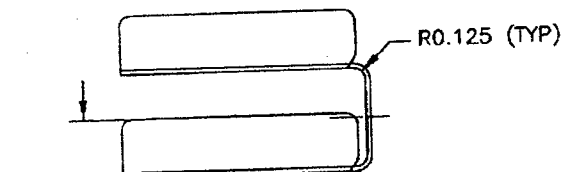


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3207	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
1/14/04



D3207-1/-2 FLAT PATTERN



D3207-1 BEND DETAIL (SHOWN)  
D3207-2 OPPOSITE

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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